

Date: Tuesday, 4/18/2006 9:58:42 AM  
 User: Kim Johnston

## Process Sheet

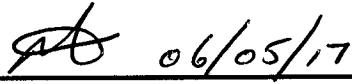
Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: SPACER		
Job Number	: 26648					
Estimate Number	: 10980					
P.O. Number	: N/A			Part Number	: D2808	
This Issue	: 4/18/2006 S.O. No. : N/A			Drawing Number	: D2808 REV A1	
Prsht Rev.	: NC			Project Number	: N/A	
First Issue	: N/A			Drawing Revision	: A1	
Previous Run	: 25248			Material	: N/A	
Written By	: See Comment Below			Due Date	: 5/15/2006	
Checked & Approved By	: J.A. 06.04.18			Qty:	50	Um: Each
Comment	: Est Rev:D 02.03.07 Now turned in house NG					

## Additional Product

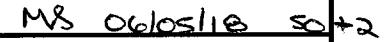
Job Number:

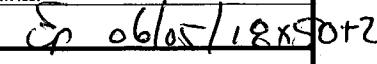


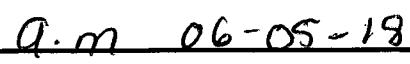
Seq. #:	Machine Or Operation:	Description :	
1.0	M6061T6R0625	6061-T6 Round Bar .625"	
2.0	HARDINGE	HARDINGE CNC LATHE SMALL	
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
4.0	QC8	SECOND CHECK	
5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1	

Comment: Qty.: 0.0557 f(s)/Unit Total : 2.7825 f(s)  
 6061-T6 Round Bar .625"  
 (M6061T6R0625)  
 Batch: M18740  06/05/17

Comment: HARDINGE CNC LATHE SMALL  
 1-Turn as per Folio FA205(Mesure D3387 Bracket .507" Dia for Proper press-fit)  
 2-Deburr

Comment: INSPECT PARTS AS THEY COME OFF MACHINE 

Comment: SECOND CHECK 

Comment: HAND FINISHING RESOURCE #1  
 Chemical Conversion Coat as per QSI 005 4.1  (52)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes  No  DQA:  Date: 06/05/09  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 4/18/2006 9:58:42 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACER

Job Number: 26648

Part Number: D2808

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

SL 06/05/18 52

7.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST388

SL 06/05/18 52

8.0 DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

SL 06/05/19 52

Job Completion



U 06-05-19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	26648
Description: Spacer	Part Number:	D2808
Inspection Dwg: D2808	Rev: A1	Page 1 of 1

## FIRST ARTICLE INSPECTION CHECKLIST

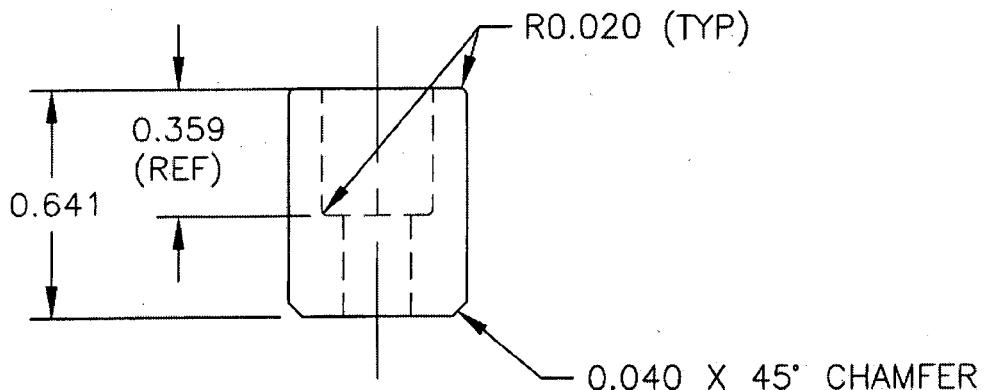
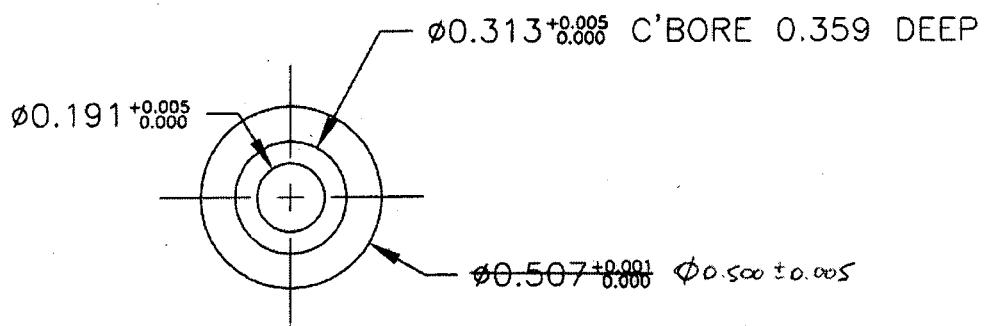
## X First Article      Prototype

Measured by: <u>BC</u>	Audited by: <u>MG</u>	Prototype Approval: N/A
Date: 06.05.17	Date: 06/05/18	Date: N/A

Rev	Date	Change	Revised by	Approved
A	05.04.26	New Issue	KJ/JLM	SJL

**DART**COPY ISSUED  
DRAFT

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKSBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. A
CP	CH	D2808	SHEET 1 OF 1
DATE		TITLE	SCALE
00.11.07		SPACER	2:1
A	00.11.07	NEW ISSUE	
A1	CP 01.04.26	ADD Powder COAT ; $\phi 0.500$ was $\phi 0.507$	

RELEASED  
00.11.13

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED  
 BREAK ALL UNMARKED SHARP CORNERS 0.010 TO 0.020  
 MATERIAL: 6061-T6 (QQ-A-250/11) OR (QQ-A-225/8)  
 FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

POWDER COAT WHITE (4.3.5.1) OR GREY SANDTEX (4.3.5.6) OR BLACK SANDTEX (4.3.5.7)  
 OR GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3

SHOP COPY  
 RETURN TO  
 ENGINEERING  
 UNCONTROLLED COPY  
 SUBJECT TO AMENDMENT  
 WITHOUT NOTICE  
 WORK ORDER  
 NO. 26648